

Work Order ID 145819

Friday, May 06, 2016 10:55:35 AM

145819

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Item ID: D4324-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Armrest Assembly
Start Date: 5/3/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/5/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: MCS Date: MAY 09 2016 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4324	B								

110

0.00

110

Small Fab

Memo

0.54

Small Fab

ASSEMBLE PART SHOWN AS PER DWG

5 FF MAY 31 2016

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.04

Quality Control

(5) DAS 38 9-89 MAY 31 2016

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

PICK AND BAG HARDWARE AS PER DWG AND NOTE 9.

5 DAS 6 9-89 MAY 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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 Required Date: 5/5/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.02				5	DAS 28 9-82		
									MAY 3 1 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>SH459</u> Memo	0.00 0.02				5			MAY 3 1 2016
									DAS 66 9-82
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							
									MAY 3 1 2016

MCS MAY 3 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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145819

D4324-011

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 14.04.24 NEW ISSUE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-4A *AN3-4A* Bolt		Purchased	No			110	Each	273.0000	1	25		16/05/31	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST350			273			5			
				m134502			273			25			
D4324-041 *D4324-041* Armrest Weldment		Manufactured	No			110	Each	6.0000	1	25		16/05/31	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST092			6			5			
				143363			6			25			
D4324-043 *D4324-043* Arm Support Assembly		Manufactured	No			110	Each	0.0000	1	25		16/05/31	DAS 36 9-89
D4324-045 *D4324-045* Cushion Assembly		Manufactured	No			110	Each	5.0000	1	25		16/05/31	DAS 36 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST455			5			5			
				119006			5			10			
AN3-4A *AN3-4A* Bolt		Purchased	No			130	Each	273.0000	2	10			DAS 6 9-89
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST350			273			10			
				m134502			273						

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 145819

145819

Parent Item: D4324-011

D4324-011

Parent Item Name: Armrest Assembly

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

AN3-12A Purchased No

130 Each 116.0000 1

AN3-12A

Bolt

DAS
28
9-89

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST349

116

m133064

16

m134257

100

MS21075L3 MS21075L3N Purchased No

130 Each 60.0000 3

MS21075L3

Nut Plate

DAS
28
9-89

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

60

m134257

60

MS51861-45C Purchased No

110 Each 14.0000 4

MS51861-45C

Screw

**

MAY 31 2016

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

14

m128993

46

m134501

10

NAS1149F0332P Purchased No

130 Each 3,408.000 3

NAS1149F0332P

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

312

m133709

312

ST262

3096

m134257

1096

m134676

2000

DAS
28
9-89

MAY 31 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Root Cause				FAULT CATEGORY					
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
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Picklist Print

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Work Order ID: 145819

145819

Parent Item: D4324-011

D4324-011

Parent Item Name: Armrest Assembly

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149F0363P

Purchased

No

130

Each

389.0000

1

25

NAS1149F0363P

DAS

6

WASHER

9-89

MAY 31 2016

Location

Loc Qty

Loc Code

ST262

389

124555

389

5

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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